





Work Order ID 65534

January 19, 2011 1:13:58 PM



Page 1

Item ID: D3929-042 Accept  Setup Start 
Revision ID: Stop 
Item Name: Gusset Assembly
Start Date: 1/19/11 Start Qty: 6.00  Cust Item ID:
Required Date: 1/25/11 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: CL Date: 1/19/11 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304 .178

1-Cut as per Dwg D3929

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B11-1-20

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65534

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Item ID: D3929-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 1/19/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/25/11 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>(46)</u>			
140 Large Fab Large Fab	Weld bushings D3907-1 as per dwg D3929 316L rod batch: <u>111585</u>	0.00 0.00							
150 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>6</u>	<u>0</u>		

8/16/170

*Op 11.01.26
BE
11.01.28*

W/O:		WORK ORDER CHANGES						
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Work Order ID 65534




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Revision ID: Stop 
Item Name: Gusset Assembly
Start Date: 1/19/11 Start Qty: 6.00  Cust Item ID:
Required Date: 1/25/11 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sulor31		(46)			
170  Packaging Packaging	Identify as per dwg & Stock Location: WA Memo	0.00 0.00		SAD 11-02-01		(B)			
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/02/02 JF mf 11-02-02

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 65534

Parent Item: D3929-042

Parent Item Name: Gusset Assembly



Start Date: 1/19/11

Required Date: 1/25/11

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

93.5003

0.45

2.842105



304/316 0.125 Sheet



B11-1-20

Location

Loc Qty

Loc Code

MAT

93.5003

114799

0.5003

116437

29

116623

64

116437

(6)

D3907-1

Manufactured

No

130

Each

25.0000

2

12



Bushing



11.0726

Location

Loc Qty

Loc Code

WA

25

64273

25

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

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D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
07/04/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A
SHEET 1 OF 3
TITLE **GUSSET ASSEMBLY** SCALE NTS

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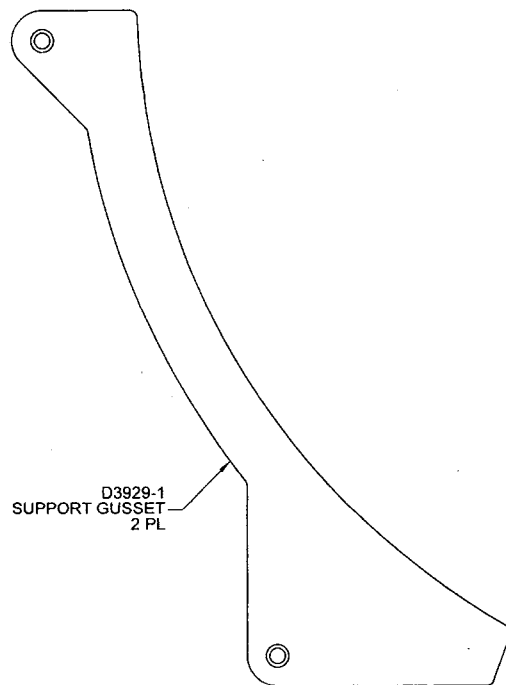
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

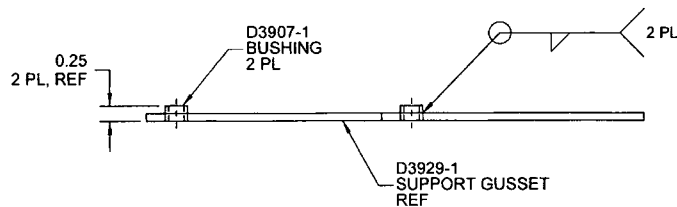
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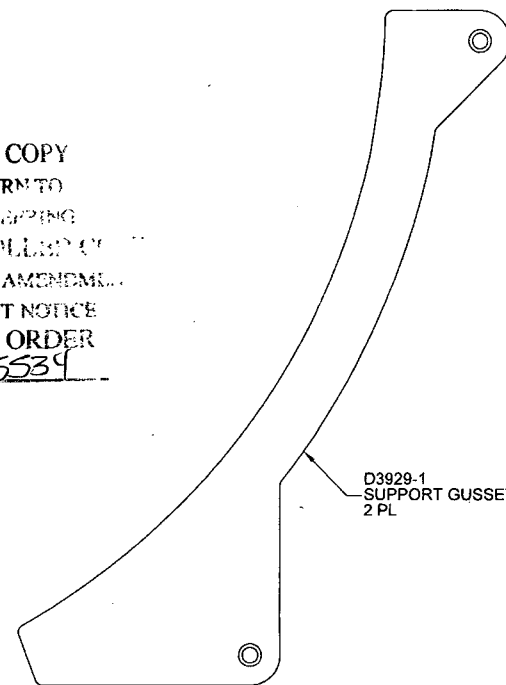
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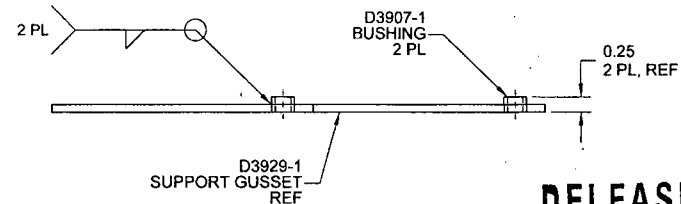
D3929-1
 SUPPORT GUSSET
 2 PL



D3929-041 GUSSET ASSEMBLY



D3929-1
 SUPPORT GUSSET
 2 PL



D3929-042 GUSSET ASSEMBLY

RELEASED
 09/04/22

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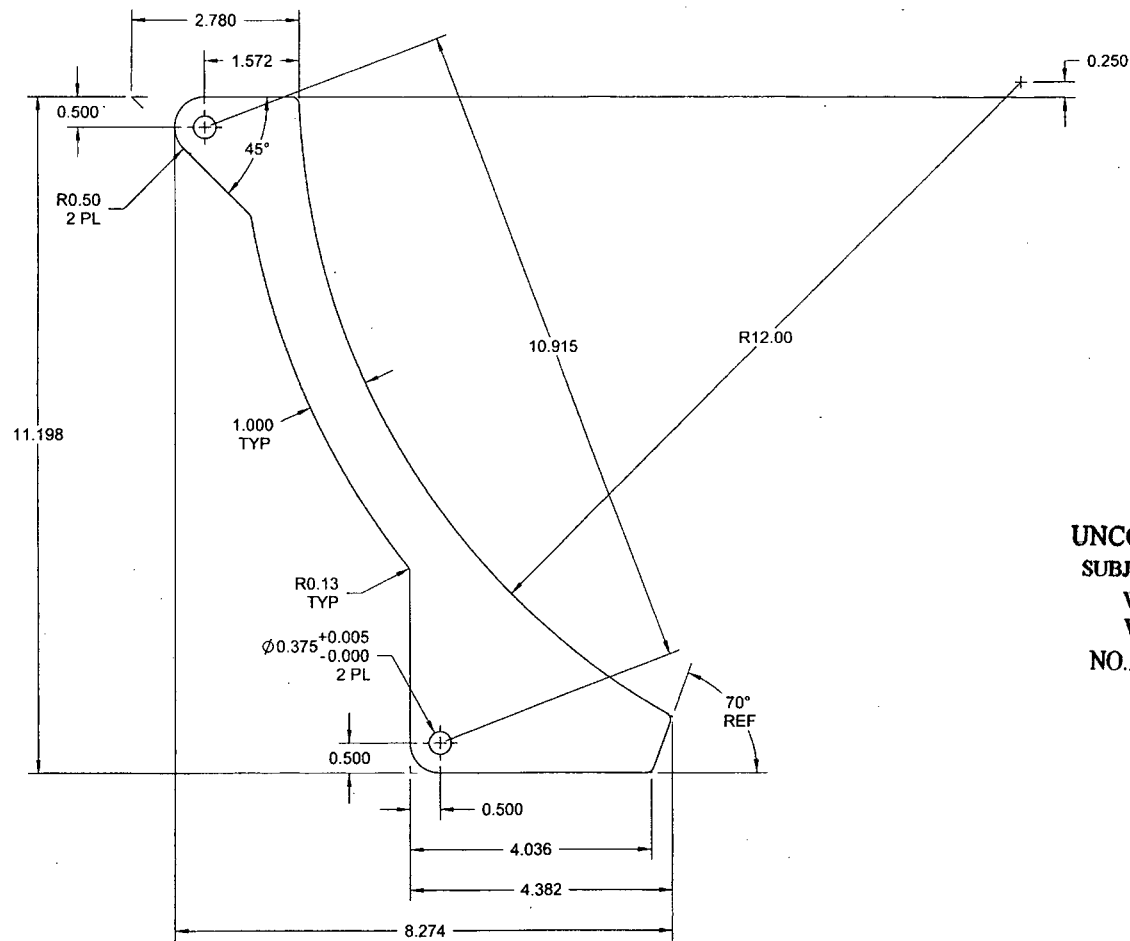
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RELEASED
9/24/22 JWD

D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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